

**Work Order ID 62846**

Page 1

Tuesday, October 12, 2010 11:22:53 AM

Item ID: D4172-3

Accept



Setup Start



Revision ID:

Item Name: Support Angle

Stop



Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: 10-10-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D4172	A	

100

0.00



Small Fab

Memo

0.00

(18)

Small Fab

- 1- Cut to lenght as per dwg
- 2- Use DT9657 to drill holes in angle, open to size as per dwg
- 3- C'sink holes as per dwg
- 4- Deburr holes

*EM-f 10/10/12*

110



QC5- Inspect part completeness to step on W/O

0.00

*10/10/12*

QC

Quality Control

Memo

0.00

(X)

-3

120



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

*ZT 10-10-12 (X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 62846**

Page 2

Tuesday, October 12, 2010 11:22:53 AM

Item ID: D4172-3

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Setup Start



Revision ID:

Item Name: Support Angle

Stop



Start Date: 10/12/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC3- Inspect Part Finish

0.00

240

10/10/12

1

6

Quality Control

Memo

0.00

140



Identify as per dwg &amp; Stock Location.

Completed

0.00

BT 10-10-12 X

Packaging

Memo

0.00

150



QC21- Final Inspection - Work Order Release

0.00

10/10/12 HJ

Quality Control

Memo

0.00

MF 10-10-12

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NOTE: Date & initial all entries

# Picklist Print

Tuesday, October 12, 2010 11:22:57 AM

Page 1

Work Order ID: 62846



Parent Item: D4172-3



Parent Item Name: Support Angle

Start Date: 10/12/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125		Purchased	No			100	f	57.5137	6.25	6.578947		m/r 10/12	

6061T6 ANGLE 1.00 x 1.00 x .125W



Location	Loc Qty	Loc Code
MAT	57.51369	
115688	4.331053	
115776	53.182637	

6-578947

W/O:		WORK ORDER CHANGES							
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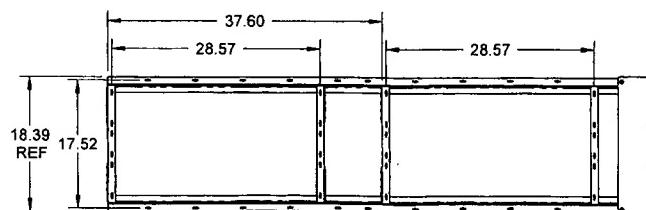
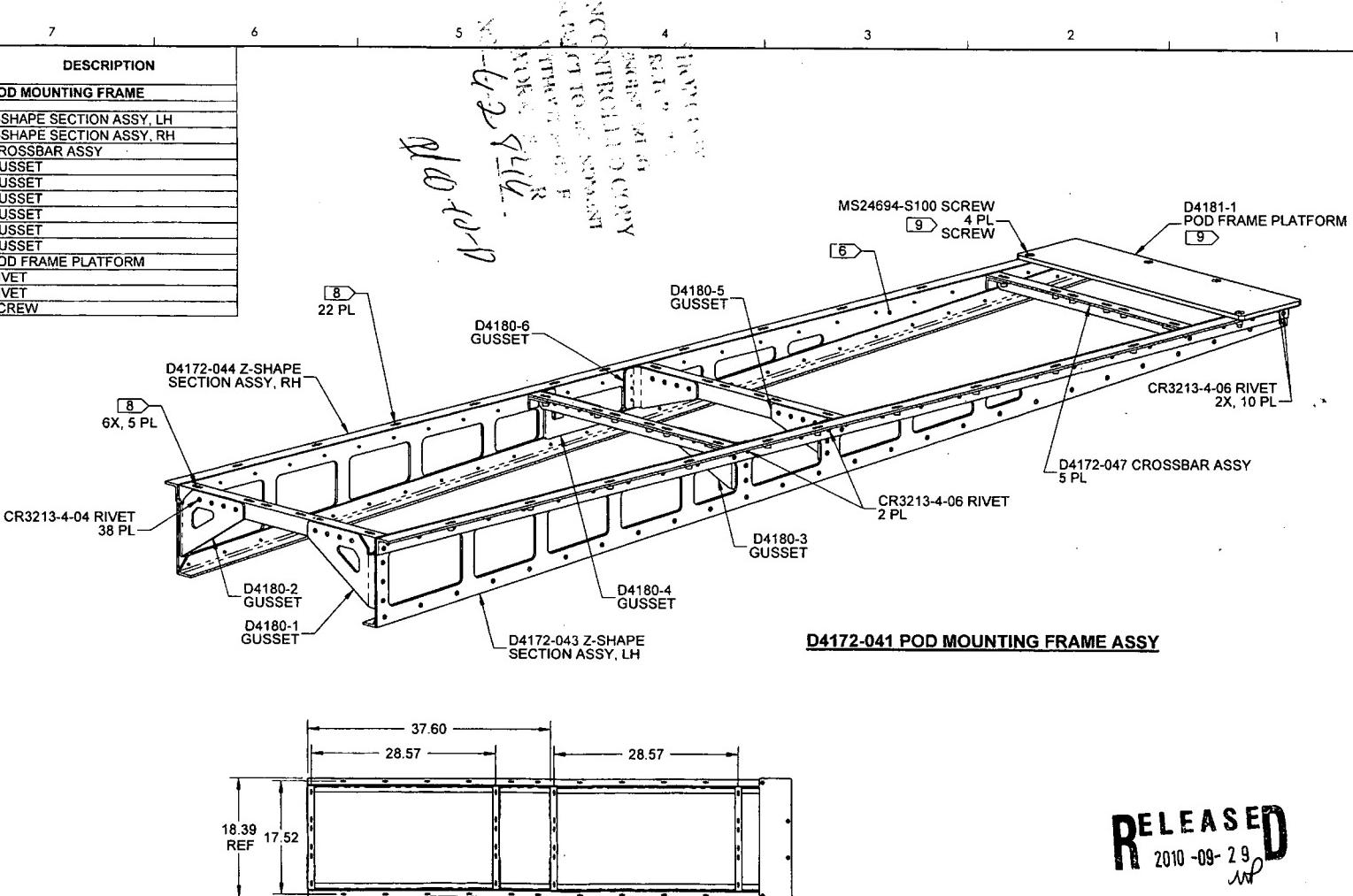
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4172-041	POD MOUNTING FRAME
1	1	D4172-043	Z-SHAPE SECTION ASSY, LH
2	1	D4172-044	Z-SHAPE SECTION ASSY, RH
3	5	D4172-047	CROSSBAR ASSY
4	1	D4180-1	GUSSET
5	1	D4180-2	GUSSET
6	1	D4180-3	GUSSET
7	1	D4180-4	GUSSET
8	1	D4180-5	GUSSET
9	1	D4180-6	GUSSET
10	1	D4181-1	POD FRAME PLATFORM
11	38	CR3213-4-04	RIVET
12	24	CR3213-4-06	RIVET
13	4	MS24694-S100	SCREW



SUPPLEMENTAL VIEWS

A	NEW ISSUE	MB	10.09.15
REV.		BY	DATE
DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AB</i>	D4172	SHEET 1 OF 7
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	POD MOUNTING FRAME ASSY NTS	
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NOTES:  
 1) MATERIAL: NONE  
 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER  
     DART QSI 005 4.3  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE  
     NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1  
     (PERMANENT INK MARKER)  
 7) WEIGHT: 15.0 lbs  
 8) MASK PRIOR TO POWDER COATING  
 9) INSTALL AFTER POWDER COATING

RELEASED  
 2010-09-29  
*AB*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

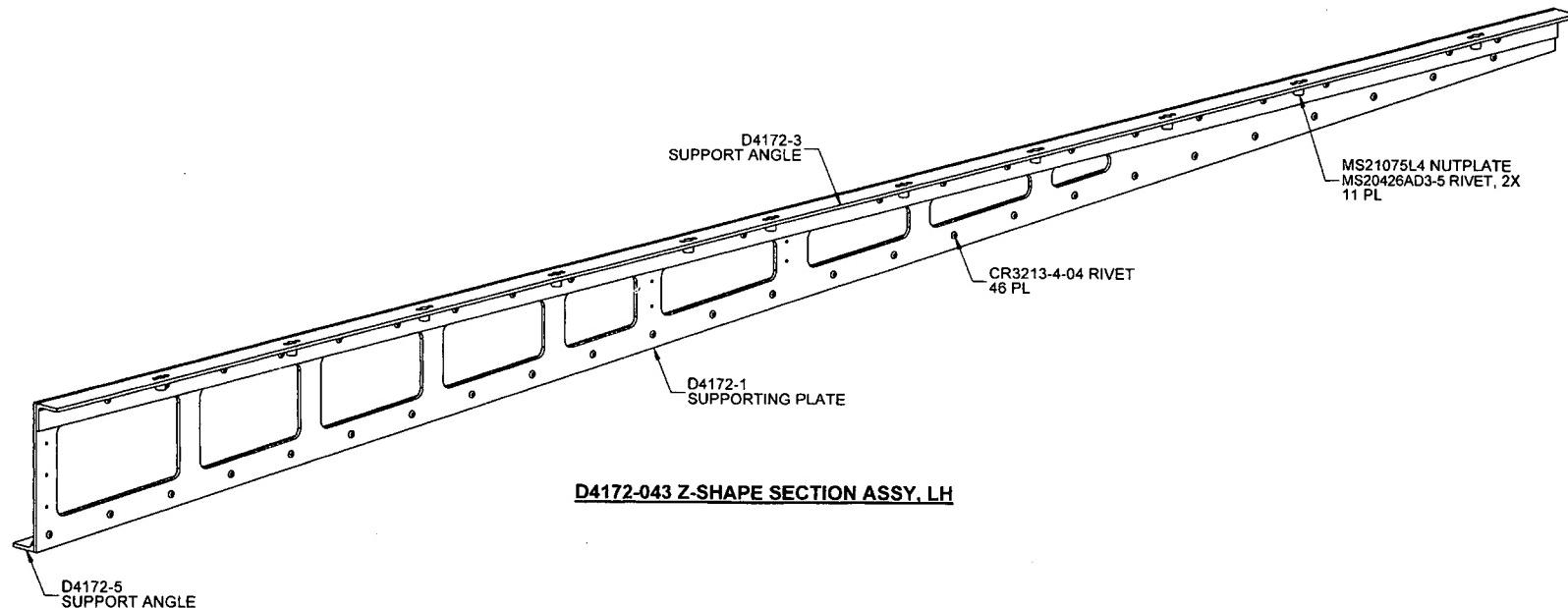
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE

W06884



D4172-043 Z-SHAPE SECTION ASSY, LH

- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 2.13 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	REV. A	
APPROVED	<i>[Signature]</i>	SHEET 2 OF 7	
DE APPR.	<i>[Signature]</i>	TITLE	
DATE 10.09.15		SCALE	
POD MOUNTING FRAME ASSY NTS			

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2010-09-29  
*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

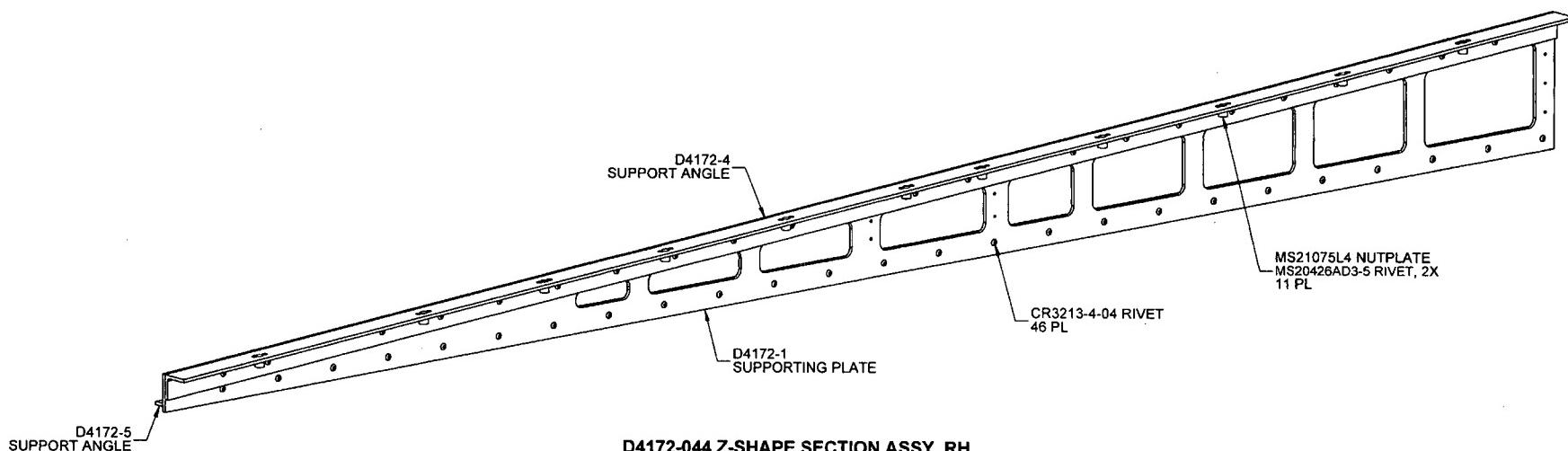
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -044	P/N	DESCRIPTION
X	D4172-044	Z-SHAPE SECTION ASSY, RH	
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-4	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE

WB 62846



D4172-044 Z-SHAPE SECTION ASSY, RH

- NOTES:  
 1) MATERIAL: NONE  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 2.14 lbs

DESIGN	8	DART AEROSPACE LTD	
DRAWN	8	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	8	D4172	SHEET 3 OF 7
APPROVED	8	TITLE	SCALE
DE APPR.	8	POD MOUNTING FRAME ASSY	NTS
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 2010-09-29  
 JK

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DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

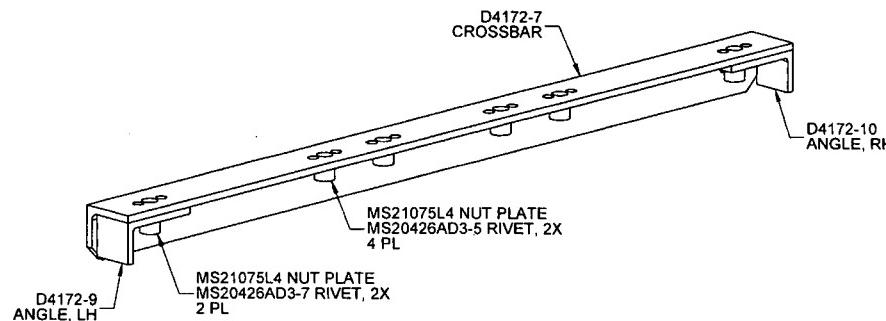
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4172-047	CROSSBAR ASSY
1	1	D4172-7	CROSSBAR
2	1	D4172-9	ANGLE
3	1	D4172-10	ANGLE
4	6	MS21075L4	NUT PLATE
5	8	MS20426AD3-5	RIVET
6	4	MS20426AD3-7	RIVET

U6A2844



**D4172-047 CROSSBAR ASSY**

- NOTES:
- 1) MATERIAL: NONE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.18 lbs

**RELEASED**  
2010-09-29  
*[Signature]*

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DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4172	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	POD MOUNTING FRAME ASSY NTS	
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

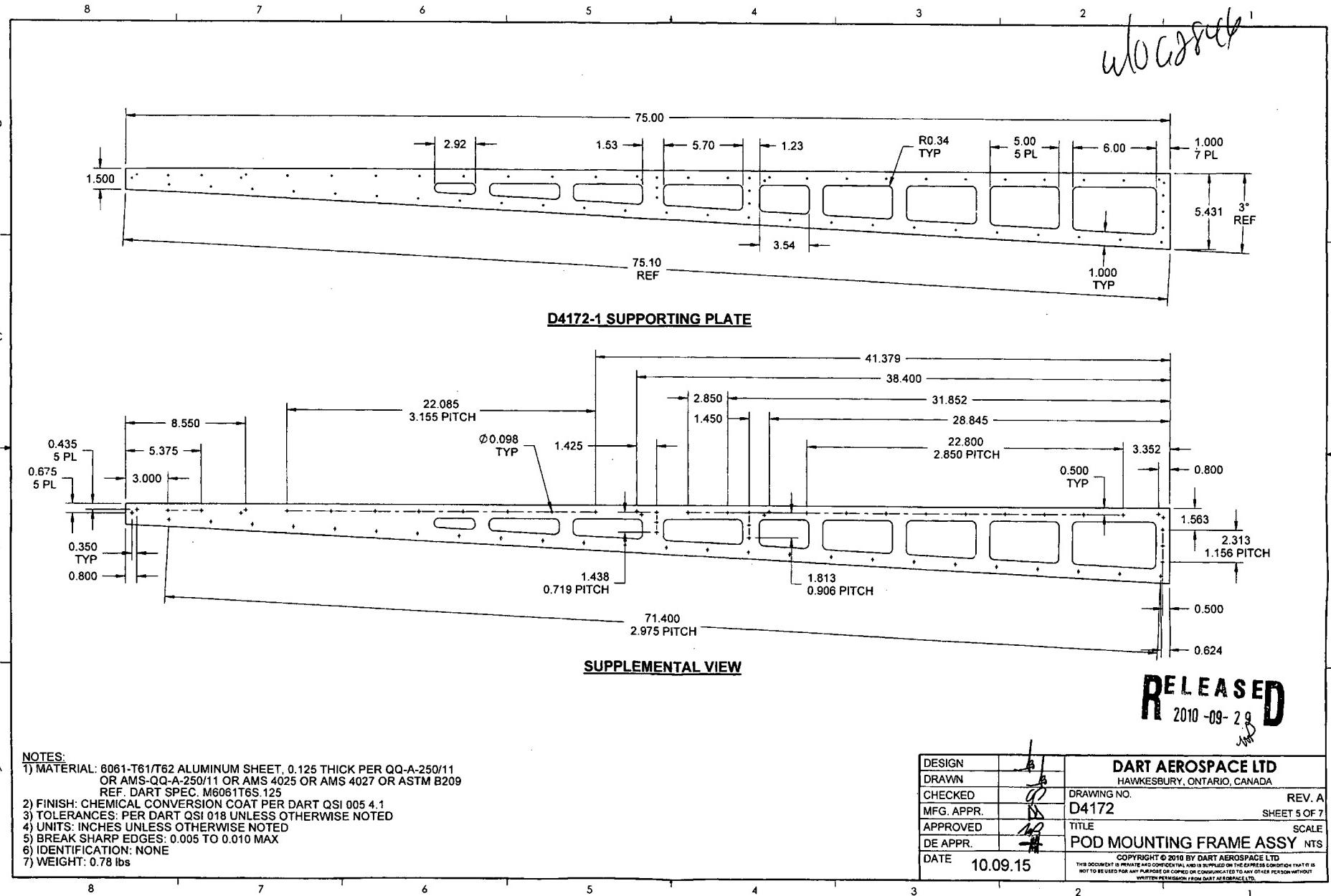
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NOTE: Date & initial all entries



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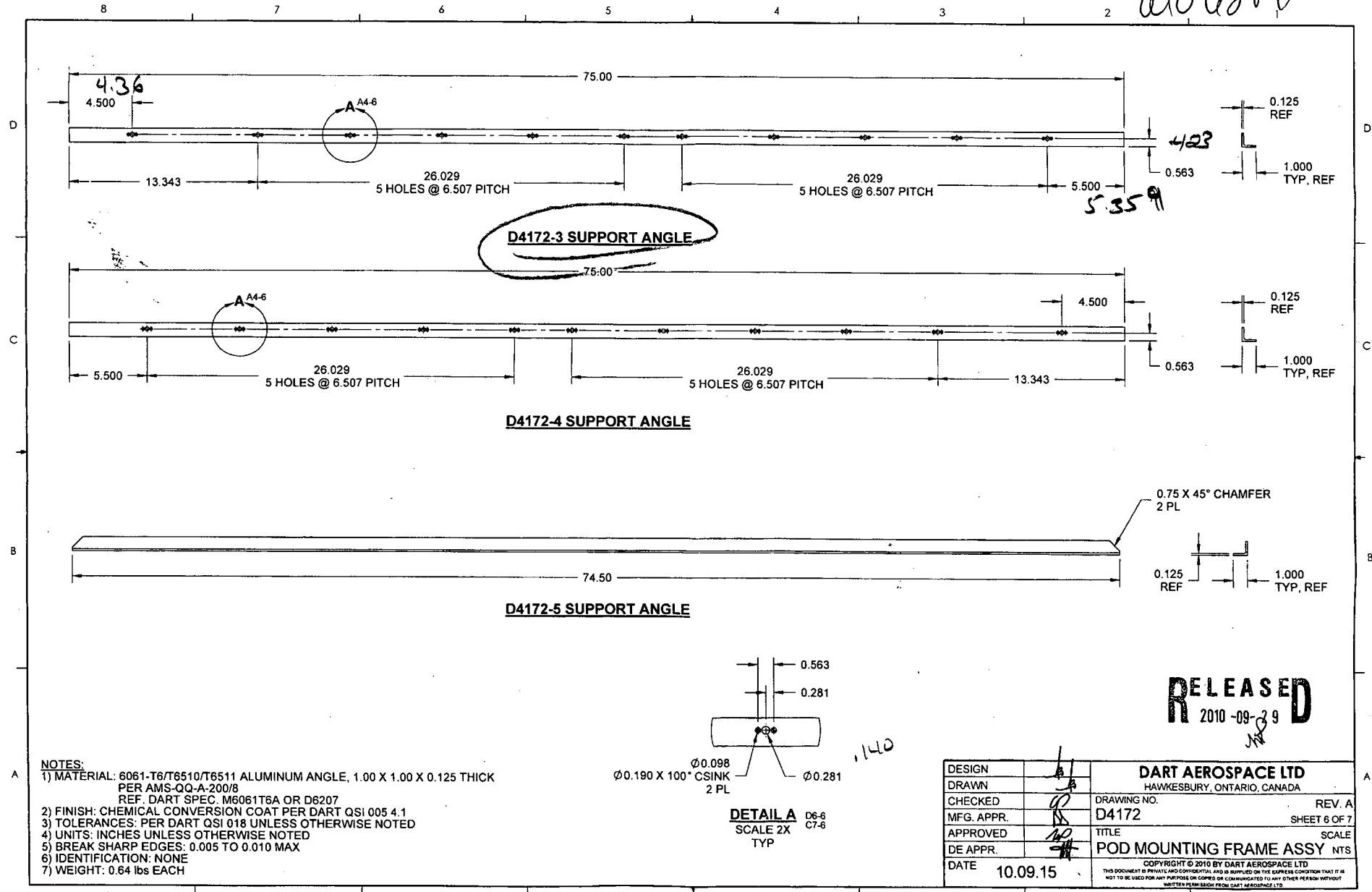
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W062846



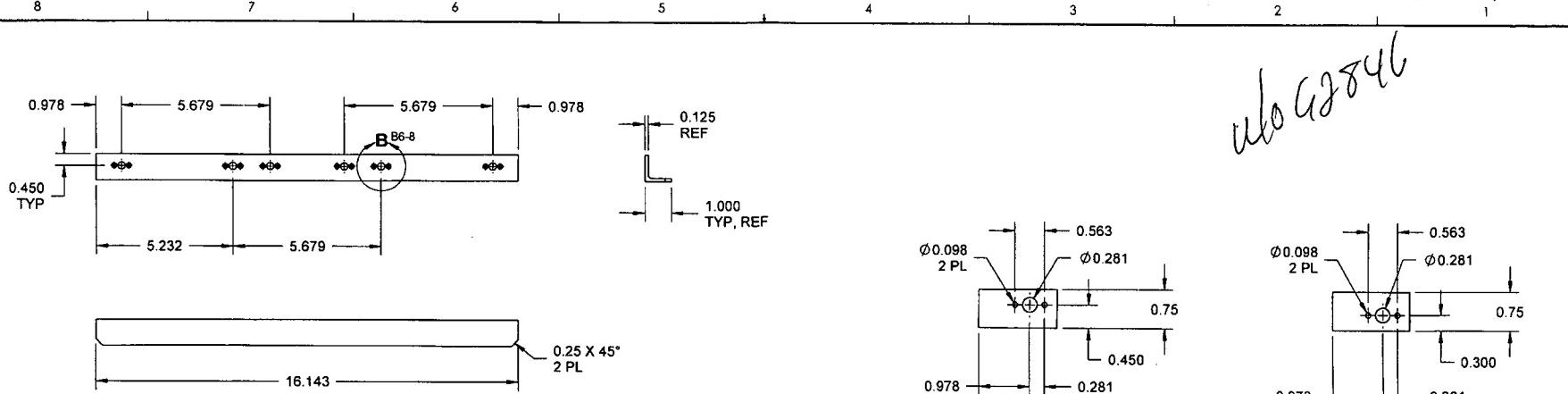
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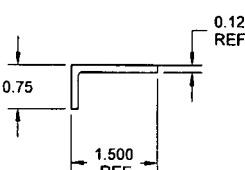
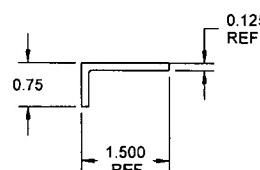
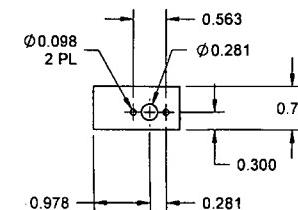
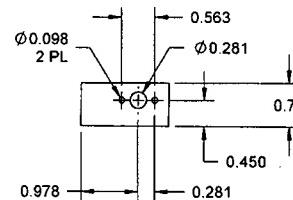
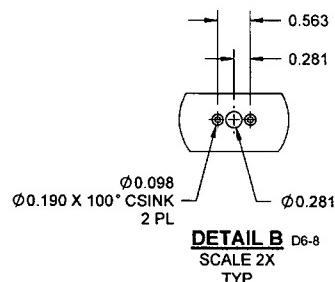
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NOTE: Date & initial all entries



D4172-7 CROSSBAR



RELEASED  
2010-09-29  
JK

NOTES:

- 1) MATERIAL  
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK  
PER AMS-QQ-A-200/8  
REF. DART SPEC. M6061T6A OR D6207
- A  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/10 = 0.01 lbs EACH

DESIGN	A	DART AEROSPACE LTD
DRAWN	✓	HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	DRAWING NO.
MFG. APPR.	✓	REV. A
APPROVED	✓	D4172
DE APPR.	✓	SHEET 7 OF 7
DATE	10.09.15	TITLE
		SCALE
		POD MOUNTING FRAME ASSY NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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